Section 1. Registration Information

Source Identification

Facility Name:	Bridor
Parent Company #1 Name:	
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	30-Apr-2020
Postmark Date:	30-Apr-2020
Next Due Date:	30-Apr-2025
Completeness Check Date:	30-Apr-2020
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0017 4063
Other EPA Systems Facility ID:	
Facility Registry System ID:	

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	127507304
Parent Company #1 DUNS:	
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	2260 Industrial Way
Street 2:	
City:	Vineland
State:	NEW JERSEY
ZIP:	08360
ZIP4:	
County:	CUMBERLAND

Facility Latitude and Longitude

Latitude (decimal):	39.515134
Longitude (decimal):	-075.065652
Lat/Long Method:	Address Matching - Nearest Intersection
Lat/Long Description:	Facility Centroid
Horizontal Accuracy Measure:	5
Horizontal Reference Datum Name:	World Geodetic System of 1984
Source Map Scale Number:	

Owner or Operator

Operator Name:	Bridor
Operator Phone:	(856) 691-8000

Mailing Address

Operator Street 1:	2260 Industrial Way
Operator Street 2:	
Operator City:	Vineland
Operator State:	NEW JERSEY
Operator ZIP:	08360
Operator ZIP4:	
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Wayne Todd
RMP Title of Person or Position:	Chief Engineer
RMP E-mail Address:	wayne.todd@bridor.com

Emergency Contact

Emergency Contact Name:	Wayne Todd
Emergency Contact Title:	Chief Engineer
Emergency Contact Phone:	(856) 691-8000
Emergency Contact 24-Hour Phone:	(856) 305-9201
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	wayne.todd@bridor.com

Other Points of Contact

Facility or Parent Company E-mail Address:	
Facility Public Contact Phone:	
Facility or Parent Company WWW Homepage Address:	

Local Emergency Planning Committee

LEPC:	Vineland City LEPC

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	180
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	

Air Operating Permit ID:

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	15-Mar-2019
Last Safety Inspection Performed By an External Agency:	State environmental agency

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:	Larry Aleksandrich
Preparer Phone:	(908) 672-2514
Preparer Street 1:	33 Monroe Avenue
Preparer Street 2:	
Preparer City:	Carteret
Preparer State:	NEW JERSEY
Preparer ZIP:	07008
Preparer ZIP4:	1808
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents: See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID:	1000108390
Description:	Ammonia Refrigeration
Process Chemical ID:	1000135493
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	69784
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	1000108390
Process NAICS ID:	1000109683
Program Level:	Program Level 3 process
NAICS Code:	31181
NAICS Description:	Bread and Bakery Product Manufacturing

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000086942

Percent Weight:	
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP Guidance for Ammonia Refrigeration Reference Tables or Equations
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Rural

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000092534

Percent Weight:	
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP Guidance for Ammonia Refrigeration Reference Tables or Equations
Wind Speed (m/sec):	3.0
Atmospheric Stability Class:	D
Topography:	Rural

Passive Mitigation Considered

Dikes:	
Enclosures:	Yes
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	Yes
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	Yes
Other Type:	

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

No records found.

Section 7. Program Level 3

Description

Ammonia Refrigeration

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000114278
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7

Process ID:	1000108390
Description:	Ammonia Refrigeration
Prevention Program Level 3 ID:	1000091918
NAICS Code:	31181

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	15-Apr-2020

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	11-Jul-2016

The Technique Used

What If:	
Checklist:	
What If/Checklist:	Yes
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	01-Jul-2021

Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	Yes
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	Yes

Earthquake:	Yes
Floods (Flood Plain):	
Tornado:	Yes
Hurricanes:	Yes
Other Major Hazard Identified:	

Process Controls in Use

Vents:	Yes
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	Yes
Dikes:	
Fire Walls:	Yes
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	Yes
Neutralization:	
None:	
Other Mitigation System in Use:	

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	
Change Process Parameters:	

Installation of Process Controls:	
Installation of Process Detection Systems:	
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	
None Recommended:	
None:	Yes
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	20-Mar-2020

Training

Training Revision Date (The date of the most recent review or revision of training programs):	13-Nov-2015

The Type of Training Provided

Classroom:	Yes
On the Job:	Yes
Other Training:	

The Type of Competency Testing Used

Written Tests:	Yes
Oral Tests:	
Demonstration:	
Observation:	Yes
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	15-Apr-2020
Equipment Inspection Date (The date of the most recent equipment inspection or test):	15-Apr-2020
Equipment Tested (Equipment most recently inspected or tested):	Daily rounds for refrigerstion equipment

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	02-Mar-2020
Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	15-Mar-2015

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):	17-Mar-2020

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit):	07-Oct-2019
Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):	07-Oct-2020

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):	
Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):	

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):	06-Sep-2004

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures):	15-Mar-2015

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):	15-Mar-2015
Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):	15-Mar-2019

Confidential Business Information

CBI Claimed:	

Section 8. Program Level 2

No records found.

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):	Yes
Facility Plan (Does facility have its own written emergency response plan?):	Yes
Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):	Yes
Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):	Yes
Healthcare (Does facility's ER plan include information on emergency health care?):	Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):	12-Jan-2019

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):	12-Jan-2019

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated):	Vineland Fire Department
Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):	(856) 691-2480

Subject to

OSHA Regulations at 29 CFR 1910.38:	Yes
OSHA Regulations at 29 CFR 1910.120:	Yes
Clean Water Regulations at 40 CFR 112:	
RCRA Regulations at CFR 264, 265, and 279.52:	
OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:	
State EPCRA Rules or Laws:	Yes
Other (Specify):	

Executive Summary

Like most bread manufacturing facilties, we use anhydrous ammonia in our refrigeration system. Ammonia is the best refrigerant available for our use. Because of its moderate toxicity and slight flammability, anhydrous ammonia is considered a hazardous material.

Bridor USA is committed to maintaining a safe bread manufacturing operation for our employees and the surrounding community. Our refrigeration system obeys our local building and fire codes, as well as industry-consensus codes and standards where appropriate. In accordance with the Federal Occupational Safety and Health Administration (29 CFR 1910.119) and Environmental Protection Agency (40 CFR 68).

Our priority is to prevent accidental releases of hazardous materials instead of merely responding to problems. Our RMP program includes elements addressing:
- Employee Participation: We involve our employees at all appropriate points in our program.
- Process Safety Information: We maintain information relating to the safety of ammonia and the refrigeration system design so that our employees are fully informed.
- Process Hazards Analysis: We conduct detailed studies of our refrigeration system to identify the important hazards and safeguards.
- Operating Procedures: We provide written operating procedures to help our staff stay within the safe operating limits of the refrigeration equipment.
- Mechanical Integrity (Maintenance and Quality Control): We have established a comprehensive program of inspections and preventive maintenance to keep mechanical failures from occurring.
- Training: We train our mechanics in safe operation and maintenance of the refrigeration system.
- Management of Change: Alterations to the refrigeration system are screened to verify that they are within the original safe design limits.
- Pre-Startup Safety Review: For certain types of major changes, we conduct a formal safety review before startup to ensure that the new equipment has been designed and installed properly.
- Contractors: We carefully screen contractors who work on our property to ensure that they have a safe work record.
- Hot Work Permits: We strictly control welding and other work that could start a fire near the ammonia equipment.
- Emergency Response: We coordinate our response to emergencies with the Vineland Fire Department.
- Incident Investigation: After an incident, we investigate to determine the causes and any suitable actions to address them.
- Compliance Audits: Every year, we examine the safety program in detail to identify areas for improvement.
- Trade Secrets: OSHA and EPA require us to maintain a trade secrets program in case confidential information affecting the safety of the ammonia refrigeration system is ever found.
- Management System: An overall management system monitors the ongoing progress of safety items.

We used the EPA's ammonia refrigeration guidance documents to estimate hazard levels.

(See the Risk Management Plan,
available from the Environmental Protection Agency, for details on the
offsite impacts; due to National Security concerns, the U.S.
Government has advised the regulated community not to disclose the
actual numerical data in this Executive Summary.)

Through our RMP program, Bridor USA looks continuously
for possible ammonia refrigeration system changes to improve safety in our facility.